

Work Order ID 56284

February 17, 2010 2:23:34 PM

Page 1

Item ID: D1049

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle

Start Date: 2/17/10 Start Qty: 12.00

Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan: *R/*Date: *10-2-17*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D1049

Rev A

100

0.00



SHEAR

Shear

Memo

Shear

Cut Blanks: 2.000" long

0.00

*HA 10/02/18**12**φ*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine as per folio FA217 & Dwg D1049
2-Deburr

0.00

*HA 10/02/18**12**φ*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

*HA 10/02/18**12**φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/
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Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

aml 10/02/18

12

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

bk 10-02-22

10

0

Hand Finishing

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

M 105642

START TIME: *1:30*

OVEN TEMPERATURE: *320°*

FINISH TIME: *2:00*

bk 10-02-22

10

Powder Coating

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Reference:

Run Start

Approvals: Process Plan:

Date: Tooling: Date:

Stop

QC:

Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

7 mi 10/02/22 12x

170

Identify as per dwg & Stock Location: 2

0.00

Packaging

Memo

0.00

Packaging

10/2/26 12x

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/03/03 12x
CL 03/01/10

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Picklist Print

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Page 1

Work Order ID: 56284



Parent Item: D1049

Parent Item Name: Saddle

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP RevC02.04.10 Re-format NG

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X00.25 0		Purchased	No			100	f	12.6400	2.1044			



6061-T6 Bar .750 x .250



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

12.64

106747

10

107904

1.81

17869

0.83

M110829

2.0000 ^{ft} H.A

10/02/18

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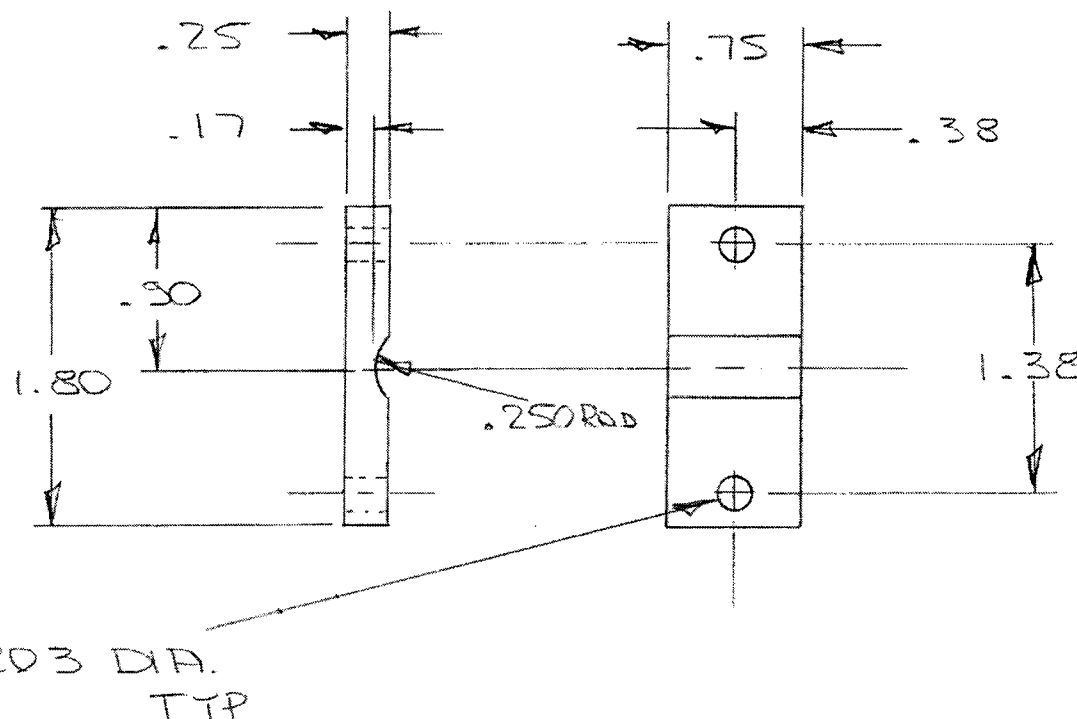
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RELEASED
97/08/02 Bw



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56284
BJ10-2-17

MATERIAL : S0S2-H32

FINISH : POWDER COAT



REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENOOR
DRAWN			BASIC CODE		CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			DIA. DASH NO. W-HEAD NEAR SIDE F-HEAD FAR SIDE G=DRIPLE DIGIT=NO OF SHEETS C=COUNTERSINK		DATE				
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		LENGTH DASH NO. W=SPOTWELD		DESIGN	TITLE			
	GENERAL		BASIC CODES		STRESS	CODE			
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .015 MAX 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - S - 2742 5. HOLES PER AND 10387		1. TOLERANCES — .001 & .030 2. ANGLES .010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		DWG NO. SCALE		REV		
	REPORT ALL DISCREPANCIES — DO NOT SCALE				CHECKED	SHT OF			

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